

BLUE

Dart Aerospace Ltd.

23

Date: Wednesday, 5/16/2007 8:14:40 AM
 User: Kim Johnston

Process Sheet

SPLIT-2

*Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW
Job Number	: 32383 - 2		
Estimate Number	: 10939		
P.O. Number	: N/A	Part Number	: D29382 Up
This Issue	: 5/16/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2938 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30481	Drawing Revision	: C
Written By	:	Material	: N/A
Checked & Approved By	: JLM 07/05/06	Due Date	: 6/6/2007
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev.C As per Rev.C 07-03-19 JLM	Qty:	: 12 Um.: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	7075-T7351 2X6.25X7.875
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length (D6101-003) Batch No: B31387 <i>Ink 07/06/20</i> (12)
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 5-Deburr <i>Ink 07/06/20</i> (12)
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <i>Ink 07/06/20</i> (12)
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
		Comment: INSPECT ALL DIM TO DIM SHEET <i>Ink 07/06/20</i> (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:14:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW

Job Number: 32383

Part Number: D29382

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/07/03

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(12x)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-h

07/07/04

7.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

NIP

8.0 QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



stock upzink!

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57447

07/07/04 (12) up

10.0 QC21

FINAL INSPECTION/W/O RELEASE

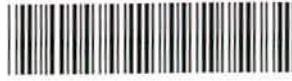


(12)

07/07/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U R.D. 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32383
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.127	0.128	0.128	0.128		
B	0.100	0.140		0.127	0.127	0.127	0.128		
C	0.100	0.140		0.117	0.115	0.116	0.117		
D	0.210	0.230		0.225	0.225	0.225	0.225		
E	1.245	1.255		1.250	1.250	1.250	1.249		
F	1.245	1.255		1.249	1.250	1.250	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.577	1.577	1.576		
J	2.495	2.505		2.499	2.499	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.119	0.119	0.120	0.119		
O	0.540	0.560		0.546	0.550	0.550	0.550		
P	0.490	0.510		0.500	0.500	0.500	0.502		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.720	2.760		2.744	2.742	2.743	2.743		
S	0.240	0.270		0.254	0.254	0.255	0.255		
T	0.100	0.180		0.138	0.142	0.138	0.146		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.250	1.270		1.260	1.260	1.259	1.259		
Y	1.565	1.585		1.576	1.576	1.575	1.573		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>mg</i>	Audited by:	<i>JL</i>
Date:	07/07/02	Date:	07/07/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JK</i>	<i>jl</i>

DART AEROSPACE LTD	Work Order:	32383
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.128	0.127	0.128	0.128		
B	0.100	0.140		0.128	0.128	0.128	0.128		
C	0.100	0.140		0.118	0.118	0.118	0.118		
D	0.210	0.230		0.224	0.225	0.225	0.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.504	2.500	2.500	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.576	1.576	1.576		
J	2.495	2.505		2.501	2.499	2.500	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.239	0.238	0.238		
N	0.100	0.140		0.117	0.118	0.118	0.119		
O	0.540	0.560		0.551	0.548	0.547	0.548		
P	0.490	0.510		0.502	0.500	0.502	0.506		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.720	2.760		2.743	2.743	2.744	2.743		
S	0.240	0.270		0.255	0.255	0.256	0.255		
T	0.100	0.180		0.146	0.146	0.141	0.141		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.326	0.326	0.320	0.320		
X	1.250	1.270		1.260	1.259	1.258	1.259		
Y	1.565	1.585		1.573	1.574	1.573	1.574		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	<i>CMR</i>	Audited by:	<i>JL</i>
Date:	<i>07/07/02</i>	Date:	<i>07/07/03</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JL</i>	<i>JL</i>

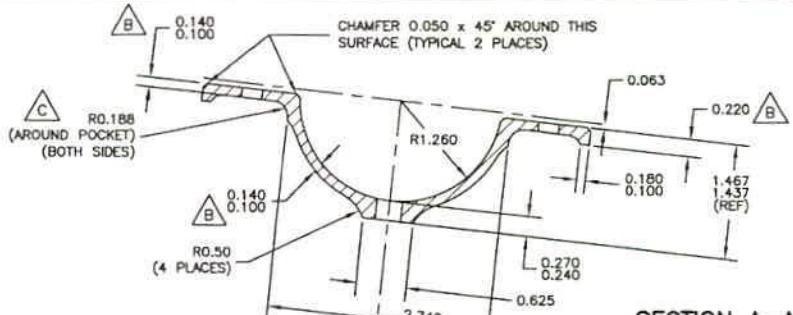
DART AEROSPACE LTD	Work Order:	32383
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

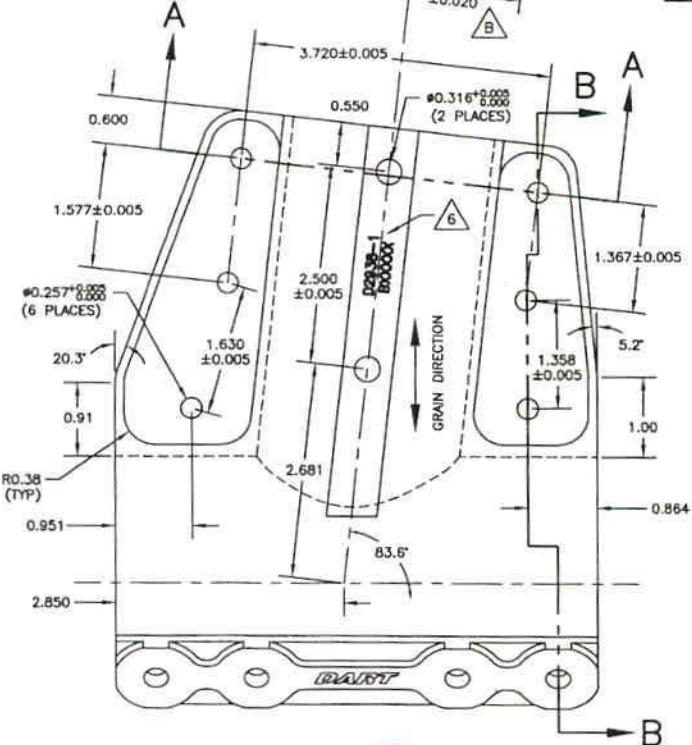
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.127	0.127	0.128	0.128		
B	0.100	0.140		0.128	0.127	0.127	0.129		
C	0.100	0.140		0.120	0.118	0.116	0.120		
D	0.210	0.230		0.225	0.225	0.225	0.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.499	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.576	1.576		
J	2.495	2.505		2.500	2.500	2.499	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.119	0.119	0.119	0.119		
O	0.540	0.560		0.547	0.544	0.550	0.546		
P	0.490	0.510		0.502	0.506	0.503	0.502		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.720	2.760		2.744	2.743	2.743	2.742		
S	0.240	0.270		0.256	0.256	0.255	0.257		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.326	0.326	0.326	0.326		
X	1.250	1.270		1.259	1.259	1.259	1.258		
Y	1.565	1.585		1.574	1.574	1.574	1.572		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>JWL</i>	Audited by:	<i>JL</i>
Date:	07/07/03	Date:	07/07/03

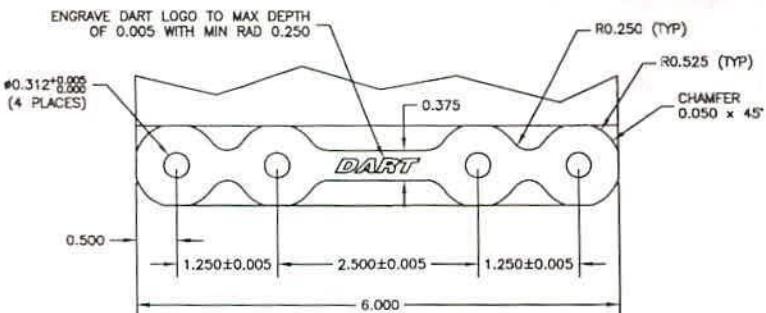
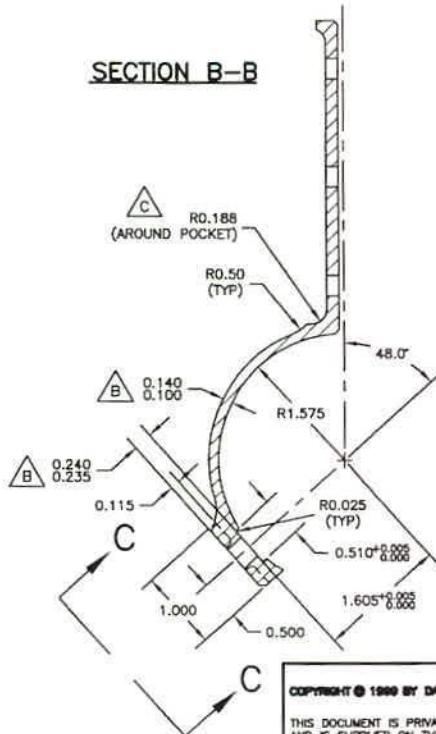
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JL</i>	<i>JL</i>



SECTION A-A



SECTION B-B



VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2938 REV. C SHEET 1 OF 1
DATE		TITLE SADDLE OUTSIDE SCALE 2.3
06.11.09		

07.02.12
SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AN ENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32383

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